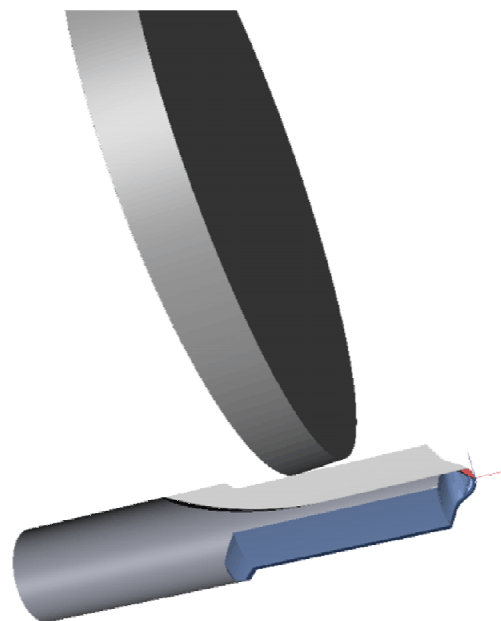


Profiled Milling Cutter R3.6Z2Ø16Ø22

A02-001

The profiled Milling Cutter was ground from solide blank Ø22mm.



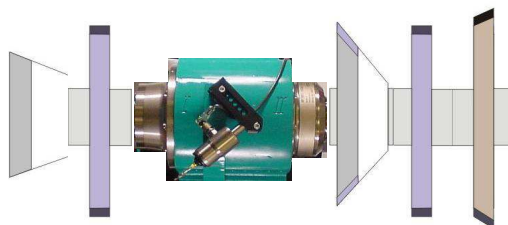
1. Cycletime for Production

Workpiece: Rohling Ø22 Material CARBIDE								
Operations								
Feed [mm/Min]	2000	25	35	60	30	35	55	10
Power [kW]		3	2	2	1	1	1	1
Cutting speed [m/s]		19	19	19	22	22	22	22
Used wheels								
Grinding time [s]	12	316	246	61	474	239	171	288
Total cycle time	30 Min 6							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	1V1 Ø125 D64
4	11V9 Ø100 D64
5	1A1 Ø125 D64



4 5

2 1 3

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR Coolant: Synthetic Oil, pressure 6 bar
Control: Fanuc 31iA5 Software: Quinto 5
Accessories: AWL 8

Responsible engineer: OP, 16.11.12

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